.

DQA:		Date:			WORK ORDER NON			22442105 / 11	22.475			DART
QA Closed:		Date:			WORK ORDER NON-	-C(JNFOI	RMANCE / U		Vork Order up	odate only	AEROSPACE
Work Orde	r·		***		DISPOSITION				AGAINST [EPARTMENT	/PROCESS	<u> </u>
Part No	0.				Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update	ı	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport	v											
Unapproved	<u> </u>					EAL	UT CAT	EGORY				
Landin	g Gear				General	r A v	OLI CAI	LGORT				
-	Bending Centre Non Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter	/Wave Tube	,	Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Ui ions Incomplete/Ui ned/off center iled	· · · · · · · · · · · · · · · · · · ·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Turning S				Finish		Out of 0	Calibration				
	Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

Work Ord Tuesday, Novem				*126	3306*							Page 2
Item ID: Revision ID: Item Name:	D3537-1 Wearpad			Accept	*N900)N4(110	n *	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	11/4/2014 11/4/2014	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item Customer:						14	. 1/
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_]	Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
1.30 Brake NC		NC BRAKE		0.00			DAS 30	46				Aluli
Brake NC		Memo 1-Form as pe Identify as D	r Dwg D3537 on CNC b.	0.00 rake using Jigs DT 8261 a	and DT 8326.2-		9-89					
140				0.00				111				4. 6.
140 Large Fab		Large Fab Memo		0.00				46				14-12-8 1001
Large Fab		m130852 Desc	ription Batc -Weld as per Dwg D353 etrated through Wearpad	thA/R 2059B Hard 7 using Jig DT 82102-Re	coat move any							BI
150		QC10- Inspect visual per	QSI004- ground welds	0.00					11/2			
150 oc		Memo		0.00	P	//5	1.12.8	8 9	6			

Quality Control

DQA:		Date:			WORK ORDER NON	~		DAAANCE / LIDDATE				DART
QA Closed:		Date:			WORK ORDER NON	-((JNFOI	RIVIANCE / UPDATE	W	ork Order up	date only	AEROSPACE
Work Orde	r:				DISPOSITION			AGAII	NST DE	PARTMENT	PROCESS	·
Part N	0.				Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Crossto Machining Small noforming Finish Large Fab Compo	Fab ning	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Diperator Diffset/Setup Process Upplier Training Training Transport Unapproved				•			•					
						FAL	ULT CAT	EGORY				
Landin	g Gear Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple it n Strip in iatter	e/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/Unqualified ions Incomplete/Unclear ned/off center led		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing /rong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
. [Wave/Tw	ist in Tuk	ne		Fit/Function		Out of s	equence				

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Work Ord Tuesday, Noven	•			*12	6306*					Page 3
Item ID: Revision ID: Item Name:	D3537-1 Wearpad			Accept	*N90004010)O*	Setup	Start Stop	*N.9	S1*
Start Date: Required Date: Reference:	11/4/2014 11/4/2014	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item ID: Customer:					
Approvals:		lan:		Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NF	२1* २੭*
Sequence ID/ Work Center II 160 *1 AO* QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00 0.00	Tool ID Tool # Plan Cod		pt Rej Qty			Insp. Stamp
170 Powdercoat Powder Coating		Grey Sandtex(Ref:4.3.5.6 Memo STAR TIM	(c).	0.00 0.00 VEN TEMPERATUR	Е:	46	<u> 6</u>	14-	12-9	8 8
180 *1 2 0*		QC3- Inspect Part Finish Memo		0.00		(46)				DAS 38 9-89

DEC 0 9 2014

Quality Control

DQA:		Date:											
QA Closed:		Data			WORK ORDER NON	-C(ONFO	RMANCE / UI		14 /-			AEROSPACE.
LA Closed.	*	Date:					<u> </u>			VVO	rk Order up	date only	
Work Orde	er:				DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS	
					Rework]		Skid-tube	Crosstube			Water Jet	Engineering
Part N	0.				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	l .	noforming	Finishing			e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier	
Root				Desc	ription of work order update		I Initial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	l	Date	Verification	QC Inspector
Design													
Doc/Data													
quip/Tooling								•					
landling/Pre										- 1			
Material							•						
Operator													
Offset/Setup													
Process										.			
Supplier													
raining													
ransport,											r y		
napproved		<u>.</u>	•									<u> </u>	
						FAI	ULT CAT	regory					
Landin	g Gear				General		,						·
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain			Ш	Over/Under	tolerance	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			-	Part Incorred	- -	Temperature/Cure
]	Crimp/Kir	nk/Ripple	e/Wave	<u> </u>	Burrs	L	Inspecti	ion Incomplete/Ur	nqualified		Part Lost/Mi	ssing	Weld
1	Cuffs				Contamination	<u> </u>	4	ions Incomplete/U	Jnclear	-	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	$oxed{oxed}$	-	ned/off center		—	Positioned V		_
1	Heat Trea			<u> </u>	Cut Too Short	<u>_</u>	Mislabe				Power Loss/:	Surge	Other
	Inspectio		Tube		Drawing	<u> </u>	Misread	d		_			
	Marks/Ch				Drill Holes		Off-set	•		_			, · · - · · · · · · · · · · · · · · · ·
ļ.	Turning S			<u> </u>	Finish	_	4	Calibration		_			
1	Wave/Tw	ist in Tul	ne.		Fit/Function	1	Out of 9	Saguence					

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Work Ord Tuesday, Nove				*126	3306*		170111000000000000000000000000000000000					Page 4
Item ID: Revision ID: Item Name: Start Date: Required Date	D3537-1 Wearpad 11/4/2014 e: 11/4/2014	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*	Accept	*N900 Cust Item 1 Customer:		100)*	Setup	Start Stop		S1* S2*
Approvals:	Process Pl	an:	Date:	Tooling: _ SPC (Y/N):		ate:			Run	Start Stop		R1*
Sequence ID/ Work Center I 190 *100* Packaging	TD	Operation Description Identify as per dwg & Stoc	k Location: 17-001	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty		keject lumber	Insp. Stamp
200 *200* OC		QC21- Final Inspection - W	Vork Order Release	0.00						14,	/12/	1 10 H)

Quality Control

A/4-12-09

DQA:			. Date:			WORK ORDER NON	c	ONICOI		IDDATE			DART
QA Closed:			Date:			WORK ORDER NON	-C(JNFOI	RIVIAINCE / C		Work Order u _l	odate only	AEROSPACE
Work Ord	er:					DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
Work Ord					-	Rework	1		Skid-tube	Crosstube	\neg	Water Jet	Engineering
Part I	No.					Scrap	1]] ,	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR I	No					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	Ш												
Handling/Pre	Ш												
Material	Ш										Ì	ł	
Operator													
Offset/Setup													
Process													
Supplier													
Training							l						
Transport													
Unapproved													
							FAI	ULT CAT	EGORY				
Landi	ng G	ear				General		_		_			
		Bending				Bend		Folio/P	rogram		Outside Dim	iensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/L	Jnqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete	/Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned \		
		Heat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	'Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	i	_			
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

Picklist Print

Tuesday, November 04, 2014 1:52:14 PM

Work Order ID: 126306

126306

Parent Item:

D3537-1

D3537-1

Parent Item Name:

Wearpad

Start Date: 11/4/2014

Required Date: 11/4/2014

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	474.4886	0.106	8			
M304S16 304/316 Sheet .063	GA								**	\$			DAS 23 14-11-10 9-89

Location	Loc Oty	Loc Code
MAT020	361.0886	
M127821	71.317	
M129449	193.7716	
M130745	96	
TPI	113.4	
M129545	113 /	

DQA:			Date:	45.										*	
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / L		Wc	ork Order up	date only	\neg	AEROSPACE
<u>.</u>						DISPOSITION						PARTMENT			
Work Ord	er: _						. 1					, , , , , , , , , , , , , , , , , , ,	_		
						Rework			Skid-tube	Crosstube			Water Jet	_	Engineering
Part N	۷o. <mark>-</mark>					Scrap			Machining	Small Fab	-		d. Eng. Coor.	_	Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	_	Other
NCR I	۷o. <u>-</u>					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	 1	nitial	A	ction		Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	۱	QC Inspector
Design						•									
Doc/Data															
Equip/Tooling	Ш														
Handling/Pre													*		
Material															
Operator														ŀ	
Offset/Setup												•			
Process														ļ	
Supplier										,					
Training															
Transport														1	
Unapproved															
							FAI	ULT CAT	regory						
Landi	ng G	ear				General							_		
		Bending				Bend		Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	et [Temperature/Cure
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/l	Unqualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruct	ions Incomplete,	/Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	- [Positioned V	-		
		Heat Trea	t			Cut Too Short		Mislabe	eled			Power Loss/:	Surge		Other
		Inspection	n Strip in	Tube		Drawing		Misread	t	•			_		
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning Se	equence			Finish		Out of 0	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence						

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DART AEROSPACE LTD	Work Order:	126306
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

Inspection Dwg:	D3537 Rev	<u>': C</u>	<u> </u>			Pa	ge 1 of 1
	FIRS	T ARTICLE IN	ISPECTI	ION CHE	CKLIST		
	r	First Artic	. —	\neg	otype		
Drawing Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Con	nments
		Dimension			mspection		
4.250	+/-0.010	4.250	<u></u>		υ	Themo i	
3.500	+/-0.010	3.7501"	+		J		
1.965	+/-0.010	1.972	_		V		
2.795	+/-0.010	2.795			U		
3.625	+/-0.010	3.625	+		J		
0.220 x 0.380	+/-0.010	0,221° ×3387°			V		
		S (FIXE & S)OL		-			
	<u> </u>						
			<u> </u>				
			1				· · · · · · · · · · · · · · · · · · ·

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							 .
<u> </u>	DAR	L	DAS 38	L		<u> </u>	
Measured by:	23	Audited by:	9-89		Prototype /	Approval:	N/A
Date:	14-11-10	Date:	NOV 1 n	2014		Date:	N/A
Rev Date	Change				Ь	evised by	Approved
	New Issue		1.	***************************************		J/JLM	Approved
B 07.04.27	Dimensions revis				K	J/JLM	1
C 07.05.28	Dimensions revis	sed per Dwg Rev	. C		K	J/JLM	all

DQA: Date:					_										
QA Closed: Date:					WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE		
QA closed. Date.															
Work Order:					DISPOSITION										
					Rework	Skid-tube (Crosstube		Water Jet			Engineering	
Part No.					Scrap		Machining Sm				Prod. Eng. Coor.			Quality	
					Use-as-is		Thermoforming Finis				Rec/Store/Packaging			Other	
NCR N	0		-		Suspected Unapproved		Large Fab Compos			Supplier					
Root				Descr	ription of work order update	<u> </u>	I Initial	Acti	ion		Sign &				
Cause	Date	Step	Qty		or non-conformance	ı	nief Eng				Date Verifi		on	QC Inspector	
Design									·						
Doc/Data															
Equip/Tooling					•										
Handling/Pre		ļ													
Material															
Operator														:	
Offset/Setup															
Process															
Supplier															
Training	_														
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Unapproved		<u> </u>													
						FAI	ULT CAT	regory							
Landin					General		7		ı		Ī		_	,	
	Bending			<u> </u>	Bend		1	rogram	gram		Outside Dimensions		L	Pressure/Forced	
	Centre Not Concentric				BOM/Route		Grain				Over/Under		\vdash	Set-up	
-	Cracks				Broken/Damage/Defect		Hardwa		<u> </u>		Part Incorrect			Temperature/Cure	
	Crimp/Kir	nk/Ripple	/Wave		Burrs		1	qualified		Part Lost/Missing		<u></u>	Weld		
ļ.	Cuffs				Contamination	-	Instructions Incomplete/Unclear			-				Wrong Stock Pulled	
-	Crushing				Countersink	-	Misaligned/off center			Positioned Wrong				1	
-	Heat Trea				Cut Too Short	-	Mislabe				Power Loss/	Surge		Other	
<u> </u>	Inspectio		Tube		Drawing	-	Misread								
.	Marks/Chatter				Drill Holes	\vdash	Off-set						_		
	Turning S			———	Finish	<u> </u>	Out of Calibration						:		
				i	Fit/Function	1 3	1Out of 9	Sequence							

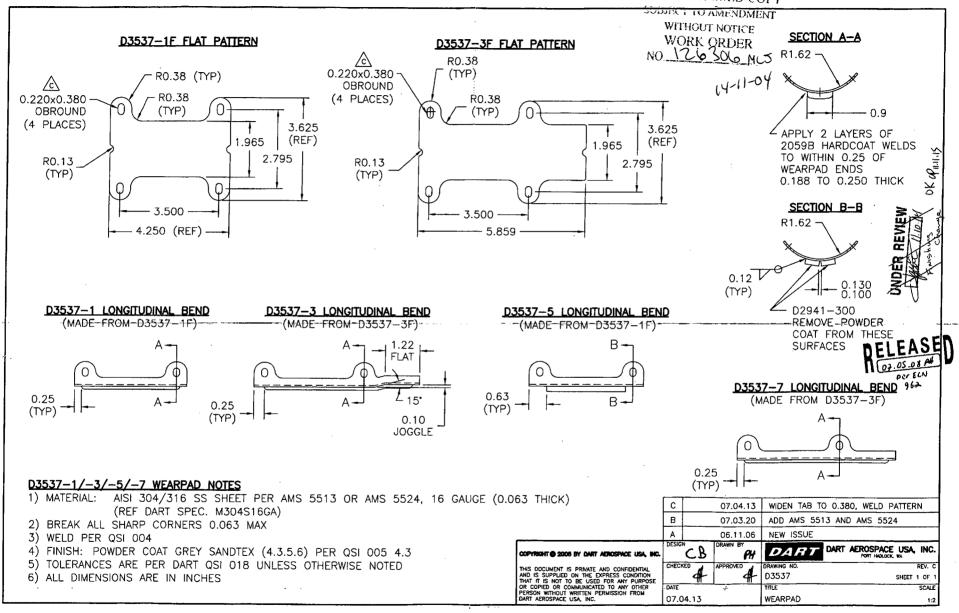
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DQA:	A: Date:													
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
Work Orde	r:				DISPOSITION			AGAINS						
Part N					Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			1	Water Jet d. Eng. Coor. re/Packaging. Supplier	Engineering Quality Other			
Root				Desci	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng Description			Date	Verification	QC Inspector		
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						FΑ	ULT CAT	regory						
Landin	g Gear				General		_			_				
L	Bending				Bend		Folio/F	rogram		Outside Dimensions Pressure/Forced				
	Centre Not Concentric				BOM/Route		Grain			Over/Under tolerance		Set-up		
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorrect		Temperature/Cure		
	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	on Incomplete/Unqualified		Part Lost/Missing		Weld		
L	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved Wrong Stock Pulled				
	Crushing				Countersink		Misalig	ned/off center	ned/off center		Vrong	,		
	Heat Trea	at [*]			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
	Inspectio	n Strip in	Tube		Drawing		Misread	t						
	Marks/Ch	natter			Drill Holes		Off-set							
	Turning S	equence			Finish		Out of Calibration							
	Wave/Tu	ist in Tuk	ne		Fit/Function		Out of	equence						

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